

Thursday, June 03, 2010 11:13:20 AM

[illegible][illegible][illegible][illegible]

Date:

3209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59386

Thursday, June 03, 2010 11:13:20 AM



Page 2

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 6/3/2010 Start Qty: 13.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 13.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 BR 10-6-10

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

8/5/10/06/14 (13)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/14

(13)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location

213

0.00



Packaging

Memo

0.00

Packaging

10-6-15

B2S

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17 JF
MF
10-6-15

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Picklist Print

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Page 1

Work Order ID: 59386

Parent Item: D3296-041

Parent Item Name: Door Assembly






Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Date: 6/3/2010

Required Date: 6/10/2010

Start Qty: 13.00

Required Qty: 13.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7  Hinge 14.0"		Manufactured	No			100	Each	0.0000	1	13		6/5/10/06/07	
D3161-9  Hinge 17.0"		Manufactured	No			100	Each	19.0000	1	13		6/5/10/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST040		19							
				52332		9							
				53228		10							
D3296-1  Door Panel		Manufactured	No			100	Each	20.0000	1	13		6/5/10/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST186		20							
				57739		7							
				57975		13							
D3296-3  Door Panel		Manufactured	No			100	Each	11.0000	1	13		6/5/10/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST186		11							
				57740		11							
MS20470AD4-6  Rivet, Universal Head		Purchased	No			100	Each	581.0000	1	13		6/5/10/06/07	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		581							
				113644		581							

B59389

(13)

9
4

7
6

13

13

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Page 2

Work Order ID: 59386

Parent Item: D3296-041

Parent Item Name: Door Assembly











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IPP Rev:D Revised Steps 06-11-20 JLM

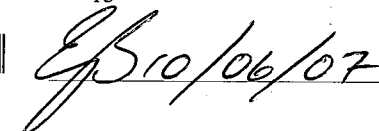
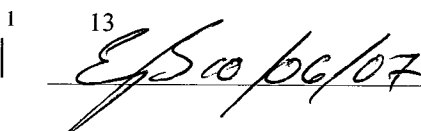
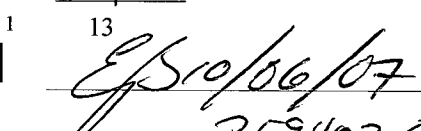
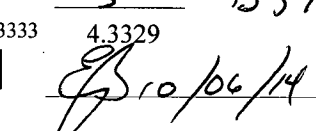
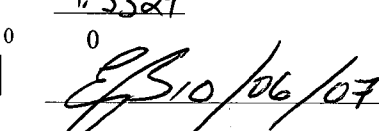
Start Date: 6/3/2010

Required Date: 6/10/2010

Start Qty: 13.00

Required Qty: 13.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6	NAS1149DN632 J	Purchased	No			140	Each	795.0000	1	13			
<div>   </div> <div>Washer</div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		795							
					104537	795							
D2137		Manufactured	No			140	Each	7.0000	1	13			
<div>   </div> <div>Decal - No Step</div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		7							
					52033	7							
D2419		Manufactured	No			140	Each	3.0000	1	13			
<div>   </div> <div>Handle</div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST014		3							
					52028	3							
D2462		Manufactured	No			140	f	637.3336	0.3333	4.3329			
<div>   </div> <div>Seal</div>													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST404		637.3336							
					48530	637.3336							
D2728-1		Manufactured	No			140	Each	0.0000	0	0			
<div>   </div> <div>Dart Logo label</div>													


13

7
B59395 (6x)

3
B59403 (6x)
B59638 (4x)

4,3329


Thursday, June 03, 2010 11:13:25 AM

Shop Packet Print

Page 2

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Picklist Print

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Page 3

Work Order ID: 59386



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 6/3/2010

Required Date: 6/10/2010

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Start Qty: 13.00

Required Qty: 13.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20470AD4-4		Purchased	No			140	Each	1,860.000	25	325			
Rivet, Universal Head													



EP 10/06/07

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	122	
112314	30	
113368	92	
ST321	1738	
114761	1738	

325

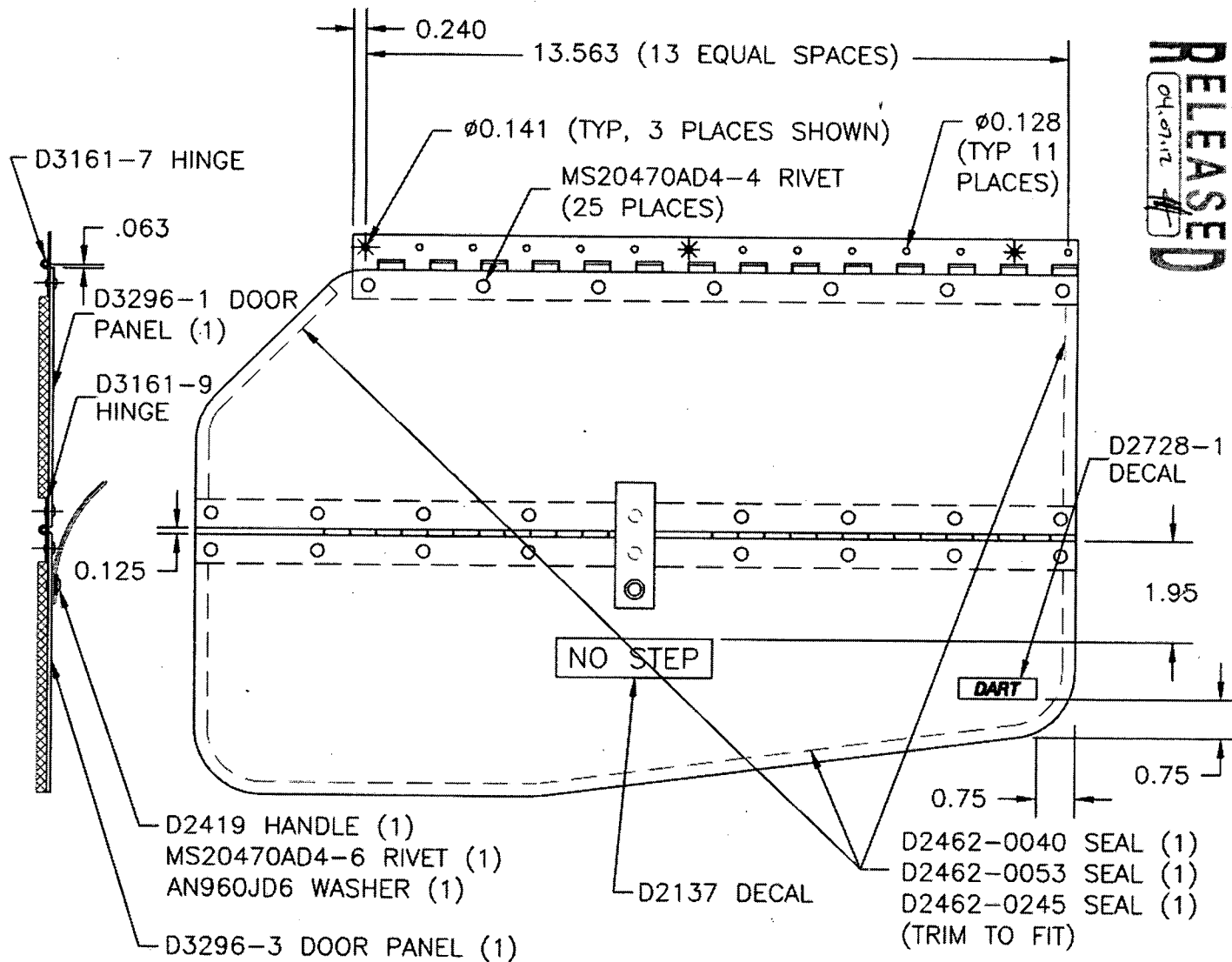
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.02

SHOP COPY
RETURN TO
ENGINE
UNCONTROLLED COPY
SUBJECT TO
WITHOUT
WORK
NO. 9



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		D3296
04.06.28		TITLE
A	04.06.28	DOOR ASSEMBLY
		NEW ISSUE
		REV. A
		1 OF 2
		SCALE
		1:3

W/O:		WORK ORDER CHANGES					
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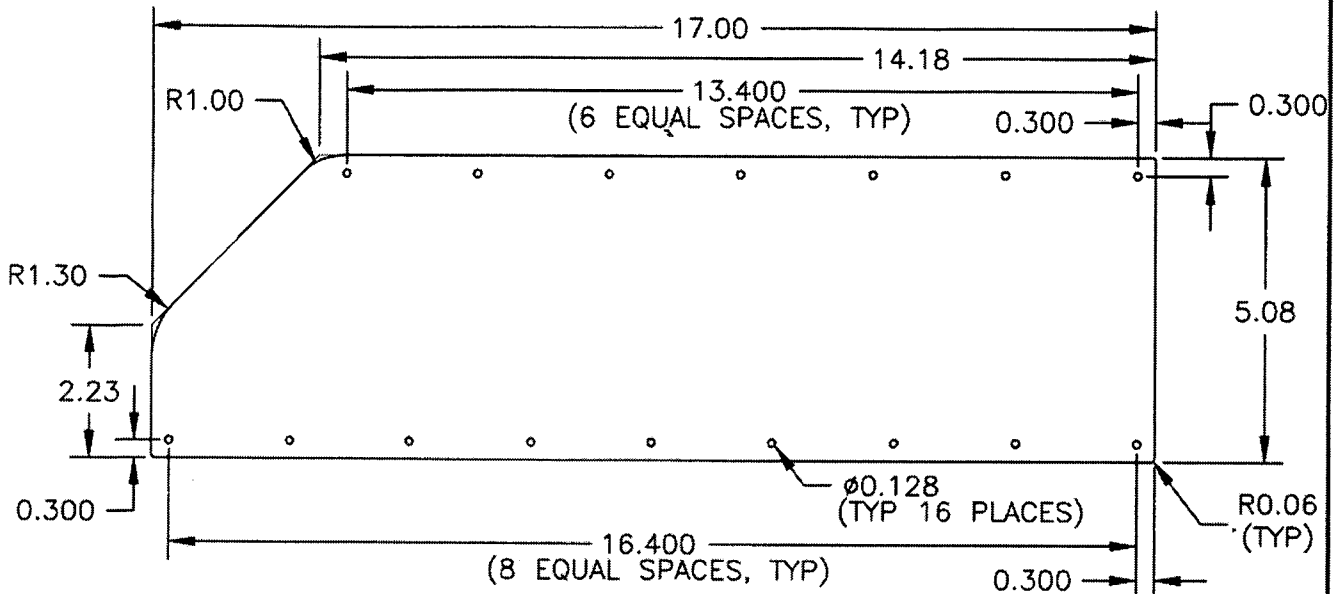
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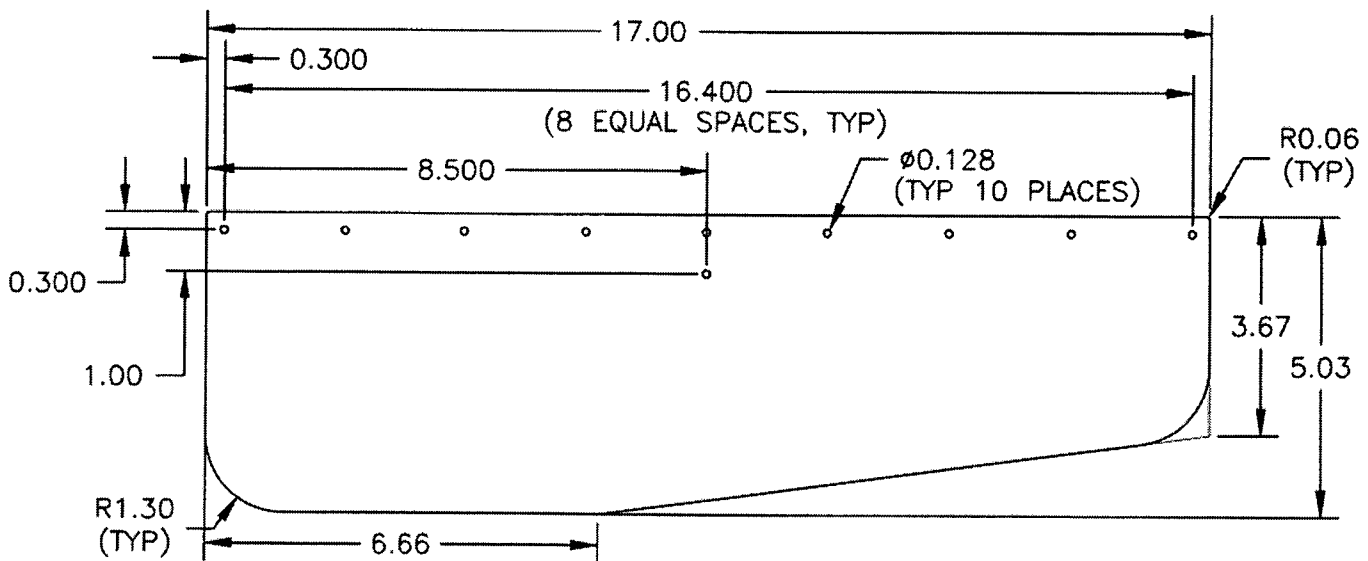
46 59384



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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